

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

Work Order ID 144185

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144185

Page 2

Item ID: D4030-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Assembly (350)
Start Date: 5/24/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/6/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00				DAS 27 9-89	DAS 28 9-89		
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

JUN 17 2016
16/6/20
MCS JUN 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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Work Order ID: 144185

144185

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530 *D2530* Handle Weldment		Manufactured	No			100	Each	2.0000	1	1			DAS 6 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST379		2							
				140965		2							
D2535 *D2535* Spring		Manufactured	No			100	Each	73.0000	2	2			DAS 6 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST008		48							
				138588		2							
				139657		46							
				ST012a		25							
				143808		25							
D2537 *D2537* Bushing		Manufactured	No			100	Each	23.0000	2	2			DAS 6 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST008		23							
				139004		3							
				141054		20							
D3913-041 *D3913-041* Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1			

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3144188 (12) JLM 16/06/16

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Work Order ID: 144185

144185

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

D3914-041 Manufactured No

100 Each 0.0000 1 1

D3914-041

Long Basket Lid Assembly (350)

**

3144190 (144) all whole

D3917-3 Manufactured No

100 Each 93.0000 6 6

D3917-3

Washer

**

144644

DAS
6
9-89

Location

Loc Qty

Loc Code

ST058

93

141536

93

D3953-3 Manufactured No

100 Each 37.0000 2 2

D3953-3

Gas Spring Stud, Lid

**

144775

DAS
6
9-89

Location

Loc Qty

Loc Code

ST062

37

138388

2

141606

35

D3953-7 Manufactured No

100 Each 38.0000 2 2

D3953-7

Spring Spacer

**

144665

DAS
6
9-89

Location

Loc Qty

Loc Code

ST062

38

138972

38

D3953-9 Manufactured No

100 Each 35.0000 2 2

D3953-9

Gas Spring Washer

**

147022

DAS
6
9-89

Location

Loc Qty

Loc Code

ST062

35

139013

2

141591

33

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Work Order ID: 144185

144185

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

D3953-17	Manufactured	No	100	Each	25.0000	2	2	
D3953-17						**	145690	DAS 6 9-89
Gas Spring Spacer								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST062	25	
141477	25	

D3953-19	Manufactured	No	100	Each	32.0000	1	1	
D3953-19						**		DAS 6 9-89
Gas Spring Bracket								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST062	32	
138913	32	

D3953-21	Manufactured	No	100	Each	24.0000	1	1	
D3953-21						**		DAS 6 9-89
Gas Spring Bracket								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST063	24	
139553	6	
141546	18	

D3969-3	Manufactured	No	100	Each	16.0000	1	1	
D3969-3						**	143820	DAS 6 9-89
Spring (Basket Lid)								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST365	16	
140555	6	
141701	10	

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Work Order ID: 144185

144185

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-14A

Purchased

No

100

Each

97.0000

4

4

AN3-14A

Bolt

**

D46
6
9-89

Location

Loc Qty

Loc Code

over003

80

m133992

50

m134360

30

ST349

17

m134167

17

4

AN3-16A

Purchased

No

100

Each

90.0000

2

2

AN3-16A

Bolt

**

D46
6
9-89

Location

Loc Qty

Loc Code

GA

45

117441

45

ST348

45

M133790

45

2

AN5-17A

Purchased

No

100

Each

152.0000

4

4

AN5-17A

Bolt

**

D46
6
9-89

Location

Loc Qty

Loc Code

GA

34

117872

34

over003

75

m134606

75

ST337

43

m134055

43

4

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Work Order ID: 144185

144185

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-12 Purchased No 100 Each 89.0000 3 3

AN4-12

Bolt

DAS
6
9-89

Location

Loc Qty

Loc Code

ST344

89

m133988

49

m134370

40

AN310-4 Purchased No 100 Each 108.0000 3 3

AN310-4

Nut

DAS
6
9-89

3

134762

Location

Loc Qty

Loc Code

GA

25

M127815

25

OVER007

75

M133990

25

M134180

50

ST331

8

M133790

8

AN310C4 Purchased No 100 Each 83.0000 2 2

AN310C4

Nut

DAS
6
9-89

Location

Loc Qty

Loc Code

OVER007

30

M134370

30

ST331

53

M133694

3

M133990

50

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2

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Work Order ID: 144185

144185

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

2,061.000

6

6

MS21042L3

Nut

**

DAS

6

9-89

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

792

m133790

6

m134360

786

Return2016

1

M132382

1

ST304

1168

m134039

12

m134360

1156

MS21042L5

Purchased

No

100

Each

462.0000

4

4

MS21042L5

Nut

**

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

140

m127813

140

ST303

322

m134055

72

m134567

250

MS24665-151

Purchased

No

100

Each

171.0000

3

3

MS24665-151

Cotter Pin

**

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

64

m128401

64

ST289

107

m133769

7

m134294

100

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6
134676

3

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Work Order ID: 144185

144185

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

47.0000

2

2

MS24665-300

COTTER PIN

**

134738

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

30

118234

30

ST288

17

M128812

17

NAS1149F0432P

Purchased

No

100

Each

1,747.000

6

6

NAS1149F0432P

WASHER

**

134502

DAS

6

9-89

Location

Loc Qty

Loc Code

ST260a

1000

M134502

1000

ST262

626

M133990

626

st268

121

M132677

121

NAS1149F0563P

Purchased

No

100

Each

114.0000

4

4

NAS1149F0563P

Washer

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST261

114

m133515

114

11

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Work Order ID: 144185

144185

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

2,281.000

8

8

NAS1149F0332P

134676

DAS

6

Washer

9-89

Location

Loc Qty

Loc Code

GA

312

m133709

312

ST262

1969

m134134

469

m134257

1500

NAS1149C0432R

Purchased

No

100

Each

1,391.000

2

2

NAS1149C0432R

DAS

6

WASHER

9-89

Location

Loc Qty

Loc Code

GA

618

m125807

428

m133790

190

ST266

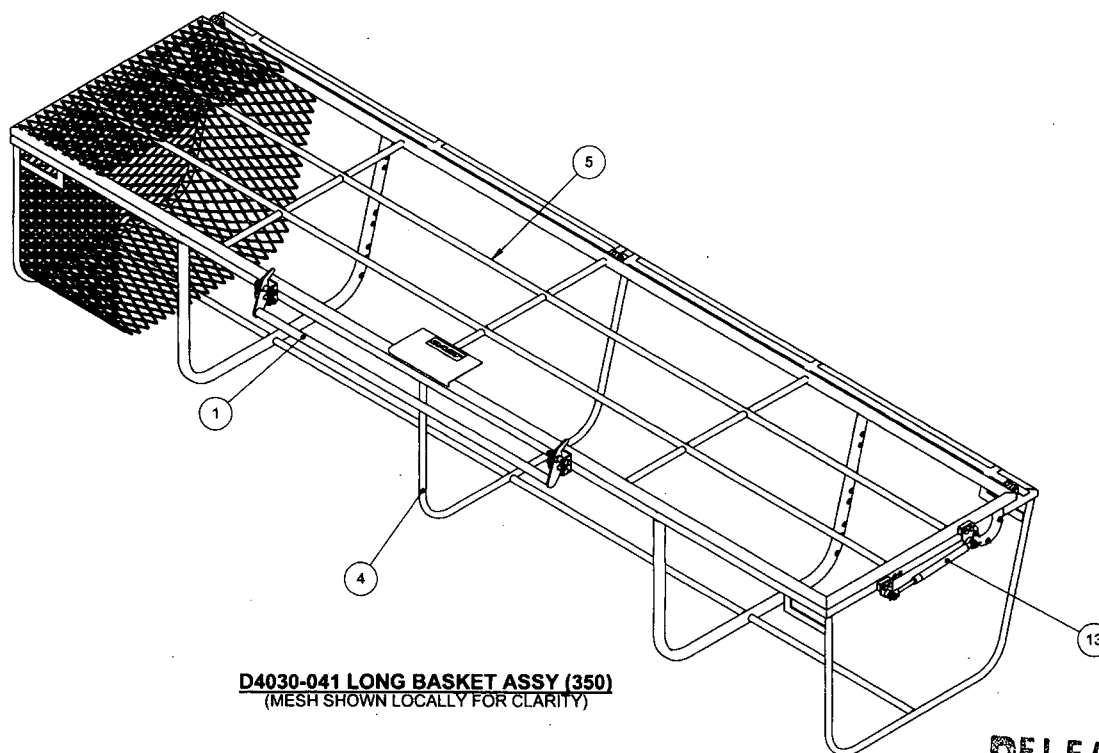
773

m134073

773

JUN 16 2016

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4030-041	LONG BASKET ASSY (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3914-041	LONG BASKET LID ASSY (350)
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT, MACHINE
15	2	AN3-16A	BOLT, MACHINE
16	3	AN4-12	BOLT, MACHINE
17	4	AN5-17A	BOLT, MACHINE
18	2	AN310C4	NUT, PLAIN, CASTELLATED
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	6	MS21042L3	NUT, SELF-LOCKING
21	4	MS21042L5	NUT, SELF-LOCKING
22	2	MS24665-300	COTTER PIN
23	3	MS24665-151	COTTER PIN
24	2	NAS1149C0432R	WASHER
25	6	NAS1149F0432P	WASHER
26	8	NAS1149F0332P	WASHER
27	4	NAS1149F0563P	WASHER



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

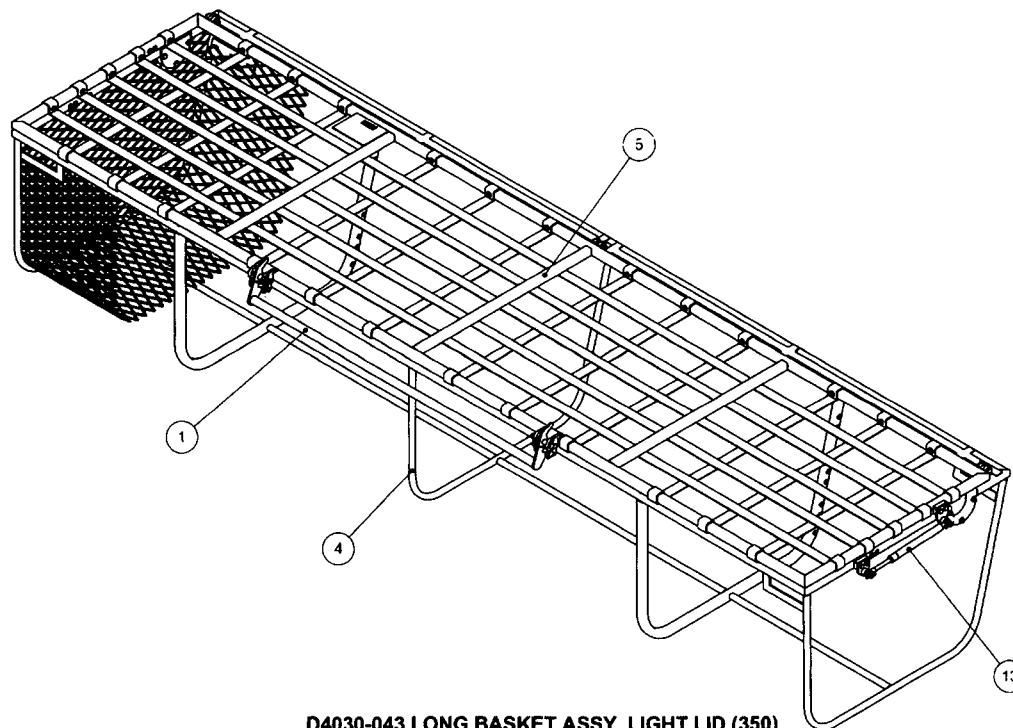
RELEASED
2013-08-16

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 72 lbs APPROX

20160405
SH 144185

D	REFORMAT FOR CLARITY. PICTORIAL UPDATE TO MULTIPLE VIEWS DUE TO CHANGES IN SUB ASSEMBLIES.	AJS	13.07.18
C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.08
A	NEW ISSUE	JPH	10.03.18
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	UP	DRAWING NO.	REV. D
MFG. APPR.	MA	D4030	SHEET 1 OF 4
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	LONG BASKET ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	P/N	DESCRIPTION
	X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3915-041	LIGHT LID ASSY, LONG BASKET
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT
15	2	AN3-20A	BOLT
16	3	AN4-12	BOLT
17	2	AN5-17A	BOLT
18	2	AN5-21A	BOLT
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	2	AN310C4	NUT, PLAIN, CASTELLATED
21	6	MS21042L3	NUT, SELF-LOCKING
22	4	MS21042L5	NUT, SELF-LOCKING
23	3	MS24665-151	COTTER PIN
24	2	MS24665-300	COTTER PIN
25	6	NAS1149F0432P	WASHER
26	4	NAS1149F0563P	WASHER
27	8	NAS1149F0332P	WASHER
28	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2013-08-16
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 57 lbs APPROX

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4030	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

